

**\*1 26934\***

Page 1

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**\*10\***

**Reference:**

Date:

Run Start \*NR1\*

Date:

Stop \*NR2\*

Draw Nbr	Revision Nbr
D4682	C

0.00

**\*1.10\***

## Waterjet

FLOW CNC Waterjet

## Memo

1-Cut as per dwg D4682

prog rev:           

dwg rev: 2

2-Deburr if required

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

## Quality Control

## Memo

0.00

**DAS**  
**23**  
**9-89**

14-12-2

**DAS**  
**23**  
**9-89**

14-12-2







**Work Order ID 126934****\*126934\***

Page 3

Item ID: D4682-9

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate Shim

Stop **\*NS2\***

Start Date: 12/2/2014 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 12/2/2014 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: WA001

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

1014-12-04 MAL

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

14/12/414-12-04



# Picklist Print

Tuesday, December 02, 2014 10:26:49 AM

Page 1

Work Order ID: 126934

**\*126934\***

Parent Item: D4682-9

**\*D4682-9\***

Parent Item Name: Wearplate Shim

Start Date: 12/2/2014

Required Date: 12/2/2014

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VERF:JLM IPP REV:B  
13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:C 14.11.24  
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			110	sf	398.7591	0.1567	2			DAS 23 9-89 14-12-2
<b>*M304S18GA*</b>									**				

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

398.75906

117188

3

117766

5

120604

5

122325

3

123155

3

124572

35.73

125552

1.1155

M126098

7.6042

M126647

31.55

M128254

34.746

M128435

35.45

M128864

11.98206

M129530

48.6185

M130345

52.9628

M130923

120

129530







DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

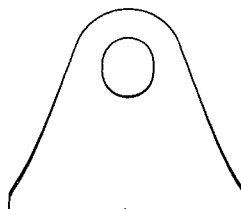
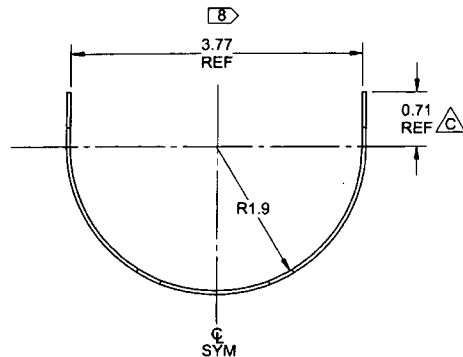
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

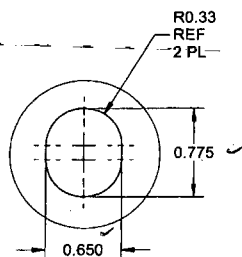
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
--	--	---	--

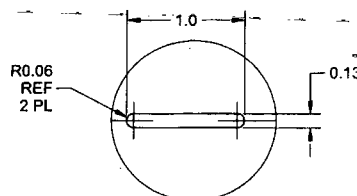
8 7 6 5 4 3 2 1



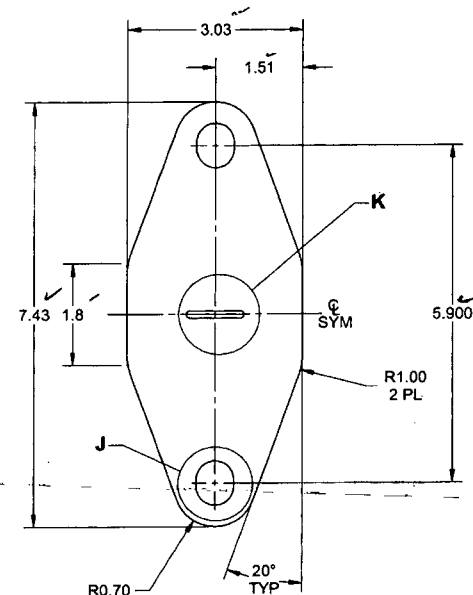
**D4682-9 WEARPLATE SHIM**  
(MAKE FROM D4682-9F)



**DETAIL J**  
SCALE 2X



**DETAIL K**  
SCALE 2X



**D4682-9F WEARPLATE SHIM**  
(FLAT PATTERN)

**RELEASED**  
2014-11-20

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.23 lbs
  - 8) IT IS ACCEPTABLE TO OVERBEND D4682-9 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

APPROVED

DESIGN	AP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AP	KENT, WA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	<b>D4682</b>	SHEET 7 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>WEARPLATE ASSY</b>	NTS
DATE	14.07.29	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

